

D2940-1 SUPPORT, 212 AFT

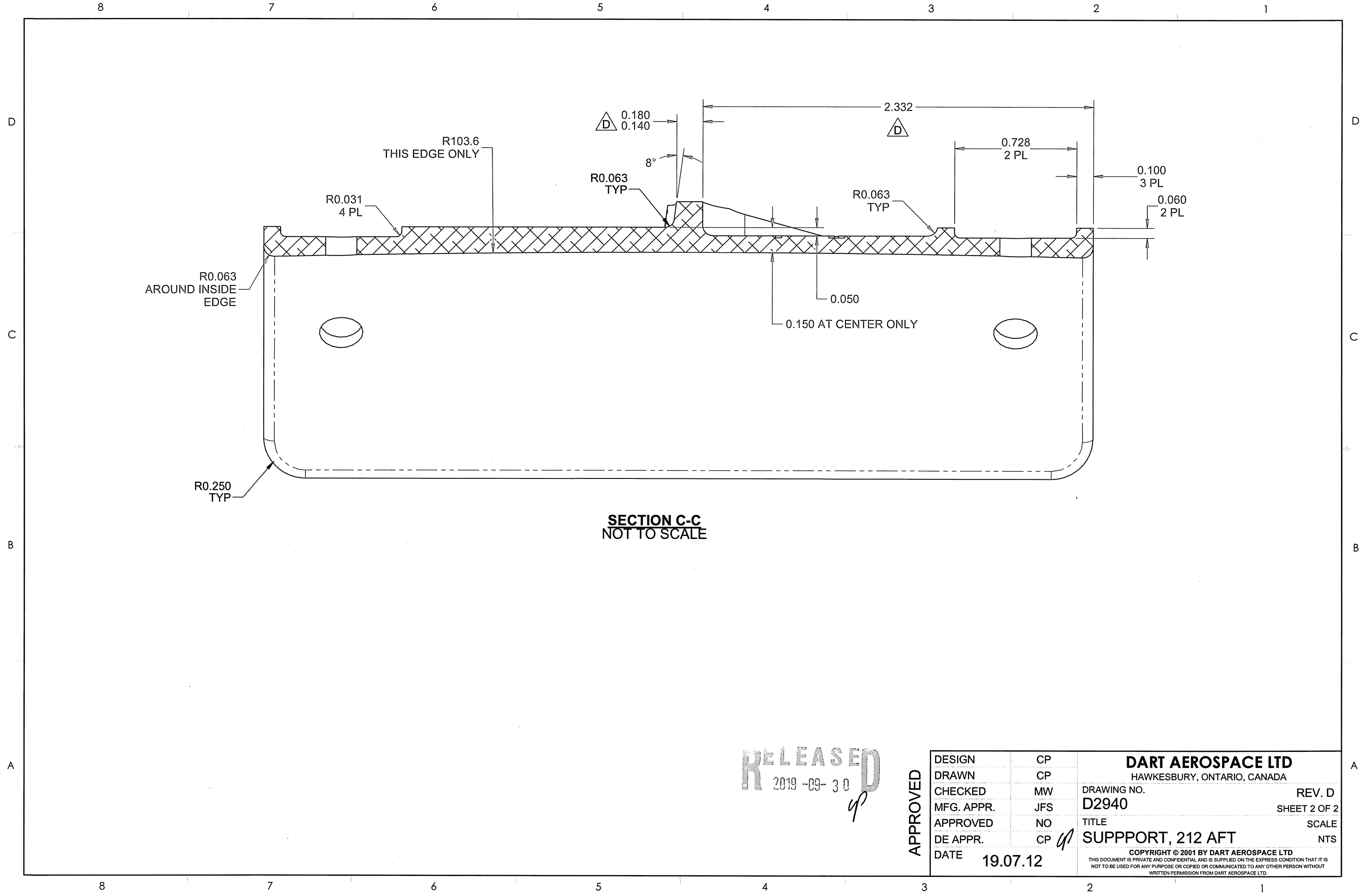
NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO, PART NUMBER, AND REVISION IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP WITH MIN TOOL RAD OF 0.010 PER DART QSI 044 6.3
- 7) WEIGHT: 0.87 lbs
- 8) MACHINE INNER CONCAVE PROFILE AND NON-DIMENSIONED FEATURES PER D2940-1-REVD.STEP
- 9) FOR THE ENTIRE INNER CONCAVE SURFACE: ABRASE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK
(OR EQUIVALENT). APPLY 0.03" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF
SUPPORT. ALLOW TO CURE FOR 24 HOURS.

RELEASED
2019-09-30
ECN 19-024

D	REDRAW IN SW, CHG INNER SURFACE PROFILE, ADD REV TO TEXT, 3M 2216 NOW 0.030 THICK, DIMS AS MFD	CP	19.07.12
C	RMV FINISH, ADD EM 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE PER NCR 642, PRIME INSIDE	PH	07.03.13
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	MW	DRAWING NO.	REV. D
MFG. APPR.	JFS	D2940	SHEET 1 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SUPPORT, 212 AFT	NTS
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SECTION C-C
NOT TO SCALE

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2019-09-30
qp

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DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	MW	DRAWING NO. D2940	REV. D
MFG. APPR.	JFS		SHEET 2 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	CP <i>qp</i>	SUPPOT, 212 AFT	NTS
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